Amendments to the Claims

1. (currently amended) An electromagnetic ~~actuating device~~ actuator, comprising:

an armature ~~(20) which is provided in a housing (10) in such a way that it can be moved~~ movable in an axial direction relative to a magnet frame ~~(12) consisting of~~ including a core section ~~(14)~~ and a yoke section; ~~(18),~~

~~and~~ a coil ~~device (24)~~ which can be ~~subjected to an electrical current in order~~ electrically energized to ~~generate the movement,~~ move said armature;

~~wherein the~~ said magnet frame ~~is designed in a~~ being hollow-cylindrical ~~manner in such a way that it~~ in configuration and at least partially ~~surrounds the~~ surrounding said armature, ~~and comprises~~ said magnet frame including an intermediate section ~~(16) consisting of~~ comprising non-magnetic material between ~~the~~ said core section and ~~the~~ said yoke section, there being a first connection interface between said yoke section and said intermediate section and a second connection interface between said intermediate section and said yoke section; and

~~characterized in that~~

~~a permanent material connection is established in~~ at least one of the ~~cross-over areas (28) between the yoke section and the intermediate section and between the intermediate section and the core section by means of a friction welding method~~ connection interfaces comprising a friction weld.

2. (currently amended) The ~~device~~ actuator ~~as claimed in~~ of claim 1, ~~characterized in that the~~ wherein at least one of said yoke section ~~and/or the~~ and said core section ~~comprises a cone shape (32)~~ has a frustoconical profile at an end facing ~~the~~ said intermediate section.

3. (currently amended) The ~~device~~ actuator ~~as claimed in~~ of claim 2, ~~characterized in that the cone shape (32)~~ wherein the frustoconical profile merges in a truncated manner into a

flat annular section ~~(34)~~ which ~~runs~~ lies in a plane perpendicular to the axial direction.

4. (currently amended) The ~~device~~ actuator ~~as claimed in any of claims 1 to 3~~ of claim 1, ~~characterized in that the~~ wherein said intermediate section ~~(16)~~ is designed as ~~an annular and/or hollow-cylindrical or solid-cylindrical~~ a tubular element which, at an end facing ~~the~~ said yoke section, ~~and/or the~~ said core section, or both, ~~comprises a cone shape~~ has a frustoconical profile adapted to the respective end of ~~the~~ said yoke section ~~and/or~~ or core section.

5. (currently amended) The ~~device~~ actuator ~~as claimed in any of claims 1 to 3~~ of claim 1, ~~characterized in that the~~ wherein said intermediate section ~~(16)~~ is designed as ~~an annular and/or hollow-cylindrical or solid-cylindrical~~ a tubular element which, at an end facing ~~the~~ said yoke section, ~~and/or the~~ said core section, or both, ~~comprises a cylinder shape~~ is flat and adapted to the respective end of ~~the~~ said yoke section ~~and/or~~ or core section.

6. (currently amended) The ~~device~~ actuator ~~as claimed in any~~ of ~~claims 1 to 5~~ claim 1, ~~characterized in that the~~ wherein said yoke section and ~~the~~ said intermediate section are formed in one piece from non-magnetic material.

7. (currently amended) A method for manufacturing a magnet frame for an electromagnetic actuator, the magnet frame ~~comprising~~ including a core section, ~~(14) and~~ a yoke section ~~(18)~~ and ~~also~~ a non-magnetic intermediate section ~~(16) lying therebetween~~ between the core and yoke sections, ~~for an electromagnetic actuating device, in particular the electromagnetic actuating device as claimed in any of claims 1 to 6,~~ by ~~establishing in each case~~ making a permanent connection between the core section and the intermediate section as ~~partners~~

mating elements of a first ~~cross-over~~ connection interface and between the yoke section and the intermediate section as ~~partners~~ mating elements of a second ~~cross-over~~ connection interface, ~~characterized by the steps~~ said method comprising:

~~- setting~~ rotating one of the ~~partners~~ mating elements of the first ~~cross-over~~ connection interface, ~~and/or of~~ the second ~~cross-over~~ connection interface, or both; ~~in a rotary movement at a predefined rotary speed,~~

[[-]] pressing the respective other ~~partner~~ mating element of the first or second ~~cross-over~~ connection interface against the rotating ~~partner~~ mating element ~~in order to give rise~~ to effect frictional heating which plasticizes the surface of the intermediate section ~~in the pressing region~~ pressed against the surface of the core section or the yoke section;

[[-]] stopping the ~~rotary movement~~ rotation; and

[[-]] pressing the ~~partners~~ mating elements against one another ~~with a predefined compression force in order~~ to produce a welded ~~cross-over~~ connection interface.

8. (currently amended) The method as claimed in claim 7, ~~characterized in that~~ which comprises producing the first ~~cross-over~~ connection interface and the second ~~cross-over~~ connection interface ~~are produced~~ at the same time.

9. (currently amended) The method as claimed in claim 7, ~~characterized in that~~ which comprises producing the first ~~cross-over~~ connection interface and the second ~~cross-over~~ connection interface ~~are produced~~ sequentially.

10. (currently amended) The method ~~as claimed in any of claims 7 to 9~~ claim 7, ~~characterized in that the predefined rotary speed of the rotary movement is set to~~ which comprises rotating one of the mating elements of the first connection interface, the second connection interface, or both at a

rotational velocity within a range between 1500 and 2500 revolutions per minute; wherein ~~min^{-1} and/or~~

pressing takes place with a pressure of between 50 and 250 N/mm^2; and wherein ~~and/or~~

the mating elements are pressed against one another with a compression force ~~as pressure is set to~~ within a range between 80 and 300 N/mm^2.

11. (canceled)

12. (new) The actuator of claim 2, wherein said intermediate section is designed as a tubular element which, at an end facing said yoke section, said core section, or both, has a frustoconical profile adapted to the respective end of said yoke section or core section.

13. (new) The actuator of claim 3, wherein said intermediate section is designed as a tubular element which, at an end facing said yoke section, said core section, or both, has a frustoconical profile adapted to the respective end of said yoke section or core section.

14. (new) The actuator of claim 2, wherein said intermediate section is designed as a tubular element which, at an end facing said yoke section, said core section, or both, is flat and adapted to the respective end of said yoke section or core section.

15. (new) The actuator of claim 3, wherein said intermediate section is designed as a tubular element which, at an end facing said yoke section, said core section, or both, is flat and adapted to the respective end of said yoke section or core section.

16. (new) The method claim 8, which comprises rotating one of the mating elements of the first connection interface, the second connection interface, or both at a rotational velocity within a range between 1500 and 2500 revolutions per minute; wherein

pressing takes place with a pressure of between 50 and 250 N/mm^2; and wherein

the mating elements are pressed against one another with a compression force within a range between 80 and 300 N/mm^2.

17. (new) The method claim 9, which comprises rotating one of the mating elements of the first connection interface, the second connection interface, or both at a rotational velocity within a range between 1500 and 2500 revolutions per minute; wherein

pressing takes place with a pressure of between 50 and 250 N/mm^2; and wherein

the mating elements are pressed against one another with a compression force within a range between 80 and 300 N/mm^2.